Work Order ID 48498

Friday, June 26, 2009 8:56:42 AM

Item ID: D3213-3
Revision ID: A
Item Name: Door Panel

Accept

Setup Start
Stop

Start Date: 7/15/2009 **Start Qty:** 10.00
Required Date: 8/3/2009 **Req'd Qty:** 10.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3213	Rev A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							
Waterjet	Memo A	0.00	HB 9-7-2						
FLOW CNC Waterjet	A								
						10			
110	QC2- Inspect parts off machine FAI/FAIB	0.00	HB 9-7-2						
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00	– 8/02/07 HB						
QC	Memo	0.00							
Quality Control									

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab	Small Fab **Memo** Deburr	0.00 0.00	IB 9-7-2						
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00	UMD 09/07/06						
150 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00	BK. 09-07-6,						

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 233	0.00				9/7/6		10x	SP
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00				09/07/07			
QC	Memo	0.00							
Quality Control									

4 09.08.07

Picklist Print

Friday, June 26, 2009 8:56:41 AM

Work Order ID: 48498

Parent Item: D3213-3RevA

Parent Item Name: Door Panel

Comments:

Start Date: 7/15/2009 **Required Date:** 8/3/2009

Start Qty: 10.00 **Required Qty:** 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	0.0000	4.9621	m 111787	9-7-2	

Date: Thursday, 11/06/2009 11:55:55 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 48498
Estimate Number : 10712
P.O. Number :
This Issue : 11/06/2009 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : SMALL /MED FAB
Previous Run : 44233
Written By :
Checked & Approved By : JLD 09.06.11
Comment : Est Rev:A New Issue 05-11-17 JLM
Est Rev:B Now on Waterjet 07-02-13 JLM

Drawing Name : DOOR ASSEMBLY
Part Number : D32133
Drawing Number : D3213 REV A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 19/06/2009 **Qty:** 10 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet

Comment: Qty.: 0.4950 sf(s)/Unit Total : 4.9497 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.063" thick
(M2024T3S.063)Identify as D3213-3
Batch: 111787 HB 9-7-2

2.0	WATER JET	FLOW WATER JET

A
A HB 9-7-2

Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-7-2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK 09/07/02 FG

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr HB 9-7-2

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Date: Thursday, 11/06/2009 11:55:55 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** DOOR ASSEMBLY

Job Number: 48498 **Part Number:** D32133

Job Number:

Seq. #:	Machine Or Operation:	Description :
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
8.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	
9.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	48498
Description: Door Panel	**Part Number:**	**D3213-3**
Inspection Dwg: D3213 **Rev:** A		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article** [ ] **Prototype**

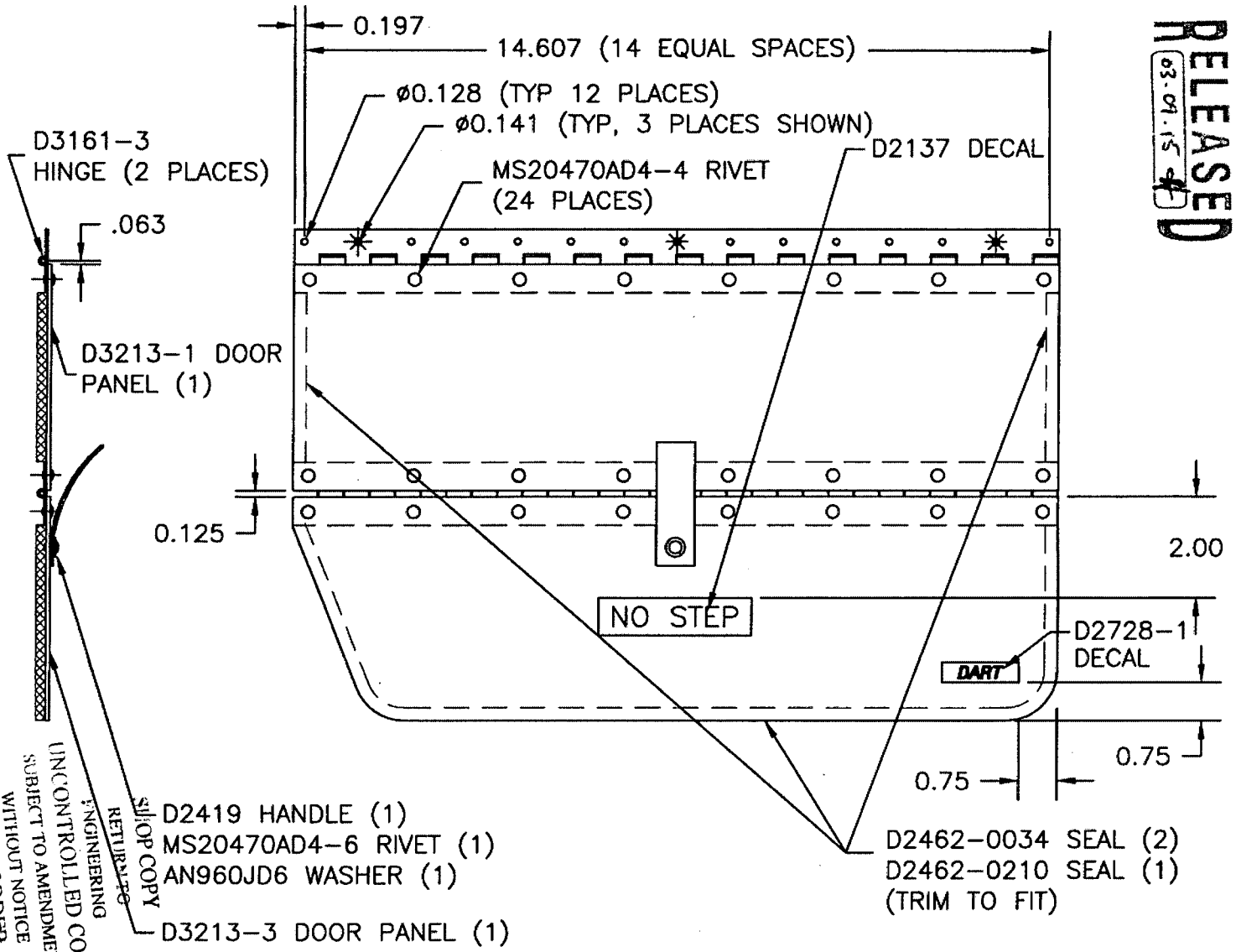
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.00	+/-0.030	15.00	X			
0.300	+/-0.010	.300	X			
14.400	+/-0.010	14.400	X			
Ø0.128	+0.005/-0.001	.129	X			
4.42	+/-0.030	4.424	X			
1.00	+/-0.030	.997	X			
0.300	+/-0.010	.301	X			
Pitch 2.057	+/-0.005	2.058	X			
.063	+/- .010	.062	X			

Measured by:	B
Date:	97-2

Audited by:	S
Date:	09/07/02

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	04.06.15	Tolerance changed for 14.400 dimension	KJ/JLM	
C	08.11.27	Diameter symbol added to dimension 0.128	KJ/EC	



RELEASED
03.09.15

DART

QA COPY ISSUED

DESIGN	DRAWN BY	DRAWING NO.	REV. A
CHECKED	APPROVED	D3213	1 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3

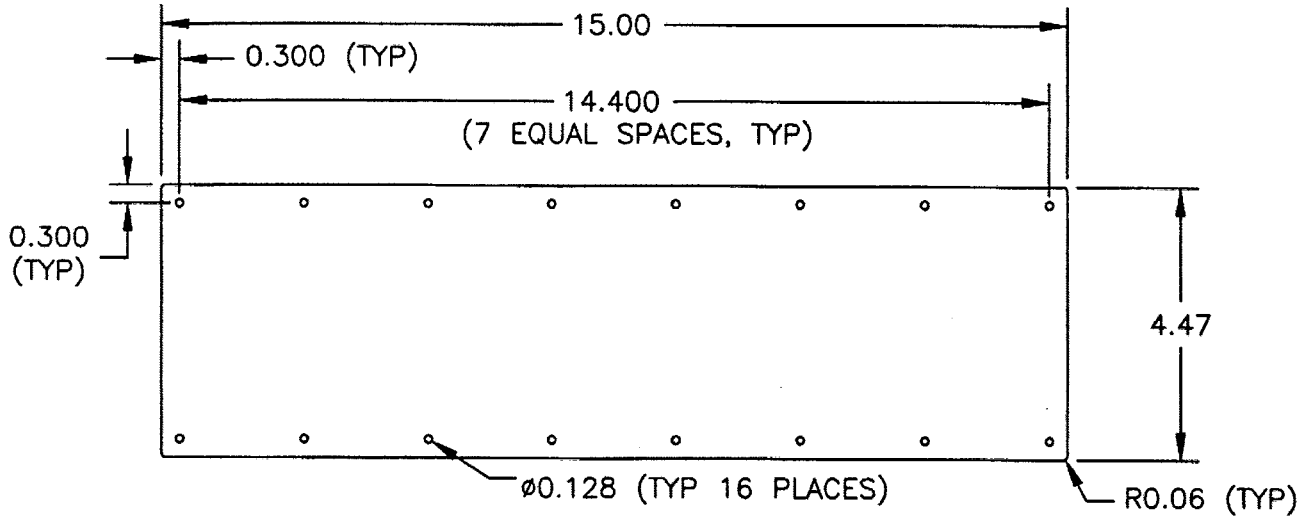
A	03.09.03	NEW ISSUE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

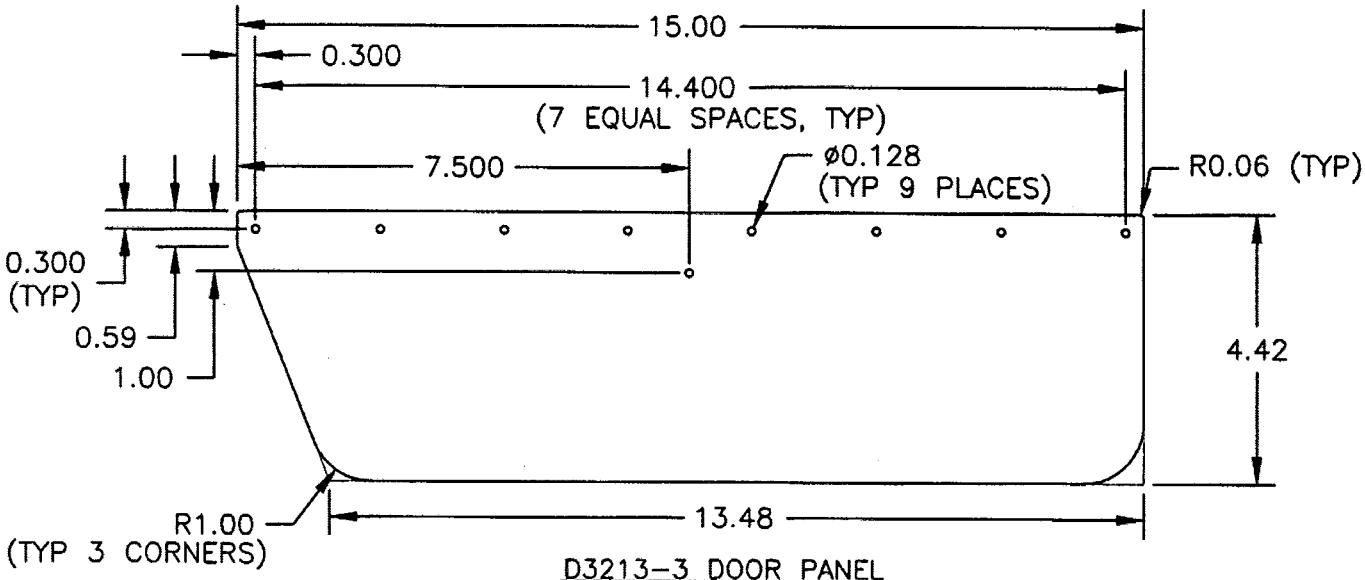
D3213-041 DOOR ASSEMBLY
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03 09 15

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